

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011474**Date Inspected:** 17-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**BAY 10**

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% and randomly Visual Testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower Strut. The weld designations reviewed are as follows.

WD1-STSA3-2-99M-2-10,11,55,51,14,15,16,13,41,42,29,30,25,26,61,64,53,54,20,21,18,22,43,44,39,31,32,27,28.  
NDT Notification No: 005073

**Tower Trial Assembly**

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% and randomly Visual Testing of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Tower lift 1 Bearing Plate. The weld designations reviewed are as follows.

SSD1-SA15 D/F- 2,4,6

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

SSD1-SA18- 4,8,10,12,16,18.

SSD1-16F/G-85,13,17,18,22,25,27.

SSD1-A111G/H-6.

SSD1-A111G/H-7

SSD1-A111B/H-46

SSD1-A111H/H-24

NDT Notification No: 005067

NDT Notification No: 005070

This QA Inspector observed the following work in progress:

### Tower Trial Assembly:

This QA Inspector observed ZPMC qualified welding personnel identified as 040367. Perform Flux Core Arc Welding (FCAW) on North Tower. Joint identified as NSD1-SA22B/E-30, Skin D, ZPMC QC Identified as Yin Chen Fang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 057266. Perform Flux Core Arc Welding (FCAW) on North Tower. Joint identified as NSD1-SA17F/G-28, Skin C, ZPMC QC Identified as Yin Chen Fang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 084069. Perform Flux Core Arc Welding (FCAW) on North Tower. Joint identified as NSD1-SA11-10, Skin A, ZPMC QC Identified as Yin Chen Fang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 058858. Perform Flux Core Arc Welding (FCAW) on West Tower. Joint identified as WSD1-SA279-21, Skin A. ZPMC CWI Identified as Zhao Chen Sun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 037907. Perform Flux Core Arc Welding (FCAW) on West Tower. Joint identified as WSD1-SA294F/G-56, Skin C. ZPMC CWI Identified as Zhao Chen Sun. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Gaikwad,Shailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

---